Date

User:

Friday, 05/09/2008 7:13:20 AM

Linda Lacelle

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 41849 : 11227

P.O. Number

Estimate Number

This Issue

: 05/09/2008

Prsht Rev. First Issue : NC : //

: 40472 **Previous Run**

Written By

Checked & Approved By

Comment

: Est Rev:A 04.07.01

Type

Est. Rev B. 07.16.2007 Thermoform in house DL Est Rev C. 08.02.06 To reflect updated Dwg. DL

THERMOFORMING

New issue KJ/JLM

Est Rev. D 08.04.15 Material Change DL

Process Sheet

Drawing Name

: FLOOR PROTCTOR FWD LH

Part Number

: D32811 . D3281 REV D

Drawing Number Project Number : N/A

Drawing Revision

: D

Material

: 12/09/2008 **Due Date**

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 MLEXS093F600602

GE PLASTICS LEXAN SHEET

Comment: Qty.:

4.3330 sf(s)/Unit Total:

21.6650 sf(s)

1106751

GE PLASTICS LEXAN SHEET

Material Batch Number HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

3.0

2.0

THERMOFORMING



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811and Folio FTA 011

Dwg. Rev. Folio Rev.

QC2 4.0

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Page 1

Form: rprocess

Dart Ae	rospace	Ltd		•								
W/O:				WORK ORDER (CHANGES					· · · · · · · · · · · · · · · · · · ·		
DATE	STEP		PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	:		PAR #:	Fault Category:	NCF	R: Yes	No DQ	A :	Date: _			
i .		Disposition:		QA:	QA: N/C Closed:							
NCR:			WORK ORDER NON-CONFORMANCE (NCR)									
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	T	Description of NC		Corrective Action Section B	Verification	Approval Chief Eng					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto			
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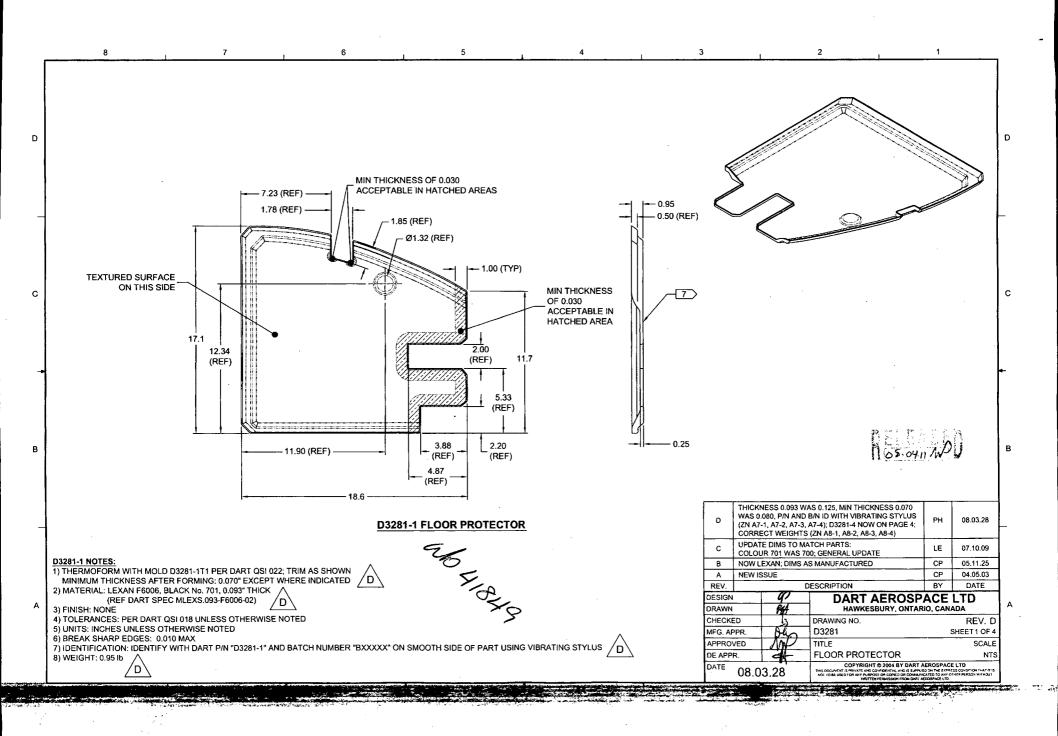
NOTE: Date & initial all entries

Date: Friday, 05/09/2008 7:13:20 AM *Linda Lacelle User: **Process Sheet** Drawing Name: FLOOR PROTCTOR FWD LH Customer: CU-DAR001 Dart Helicopters Services Part Number: D32811 Job Number: 41849 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING THERMOFORMING HAND FINISH TH 5.0 Comment: HAND FINISHING THERMOFORMING 1) Trim to Finished Dimensions INSPECT PARTS AS THEY COME OFF MACHINE QC2 6.0 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 1) Check Surface finish for undesired marks, voids, dimples etc. 2) Check dimensions to ensure conformity to drawing tolerances. INSPECT WORK TO CURRENT STEP 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 8.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 FINAL INSPECTION/W/O RELEASE 9.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

Dail Ac	Uspace	Ltd		•									
W/O:			WORK ORDER CHANGES										
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NOTE: Date & initial all entries



DART AEROSPA	ACE LTD			Wo	rk Order:	41849		
5					D3281-1			
Description: Floor	Protector, Fwd LH			Pa	rt Number:	D3261-1		
Inspection Dwg: D	3281 Rev : D					Page 1 of 1		
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	TH	HERMOFORM	ING SE	CTION				
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Material imperfection scratching	cracks, voids,							
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Measured by:	**]		Date:	108/09/00		
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Drawing Dimension	Tolerance	1	Accept	Reject	Method of Inspection	Comments		
_	Tolerance +/-0.100	Actual Dimension				Comments		
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Dimension 18.6	+/-0.100	Actual Dimension	Accept			Comments		
18.6 17.1	+/-0.100 +/-0.100	Actual Dimension 18.625 17.125	Accept			Comments		
18.6 17.1 11.7	+/-0.100 +/-0.100 +/-0.100	Actual Dimension 18,625 17.125	Accept			Comments		
18.6 17.1 11.7 0.95	+/-0.100 +/-0.100 +/-0.100 +/-0.030	Actual Dimension 18.625 17.125	Accept			Comments		
18.6 17.1 11.7 0.95 0.25	+/-0.100 +/-0.100 +/-0.100 +/-0.030 +/-0.030 Min ±/-0.010	Actual Dimension 18,625 17.125	Accept			Comments		
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18.6 17.1 11.7 0.95 0.25 0.030	+/-0.100 +/-0.100 +/-0.100 +/-0.030 +/-0.030 Min ±/-0.010	Actual Dimension 18,625 17,125 950 .250	Accept			Comments		
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18.6 17.1 11.7 0.95 0.25 0.030	+/-0.100 +/-0.100 +/-0.100 +/-0.030 +/-0.030 Min ±/-0.010	Actual Dimension 18,625 17,125 950 .250	Accept			Comments		
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Approved

Revised by KJ/DL KJ/DL

Rev A B DateChange08.02.28New Issue08.04.16Dimensions updated per Dwg Rev D

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DART AEROS	PACE LTD	Wo	rk Order:	41849			
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Description: Floo	r Protector, Fwd LH			Pa	rt Number:	D	3281-1
Inspection Dwg:	D3281 Rev : D					Pag	ge 1 of 1
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B 08.04.16	Dimensions updated	per Dwg Kev D	,		NJ/DL	-JKI	

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A 08.02.28			KJ/DL	1//	101				
B 08.04.16 Dimensions updated per Dwg Rev D KJ/DL									